

Work Order ID 70465

Thursday, June 09, 2011 7:43:13 AM



Page 1

Item ID: D3536-33

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 6/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Debur if necessaryB11-6-9

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5 w/06609

Work Order ID 70465

Thursday, June 09, 2011 7:43:13 AM



Page 2

Item ID: D3536-33

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 6/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: *FP*

0.00

Memo

0.00

11/6/9 *sf* *160*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/6/13 *MF*
11-06-10

Picklist Print

Thursday, June 09, 2011 7:43:10 AM

Page 1

Work Order ID: 70465



Parent Item: D3536-33



Parent Item Name: Gasket

Start Date: 6/9/2011

Required Date: 6/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	100.6800	0.6456	8.608			



B11-6-9

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

100.68

117295

100.68

117295



DART AEROSPACE LTD		Work Order: 70165
Description: Gasket		Part Number: D3536-33
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.191	>		V B02	
0.30	+/-0.030	.302	>		V	
0.30	+/-0.030	.307	x		V	
1.89	+/-0.030	1.884	>		V	
6.00	+/-0.030	6.00	>		T B01	
6.75	+/-0.030	6.75	x		T	
13.50	+/-0.030	13.50	x		T	
2.00	+/-0.030	2.00	>		T	
6.00	+/-0.030	6.00	>		T	
9.50	+/-0.030	9.50	>		T	
15.25	+/-0.030	15.25	x		T	
21.00	+/-0.030	21.00	x		T	
24.50	+/-0.030	24.50	>		T	
0.063	+/-0.010	.063	>		V	

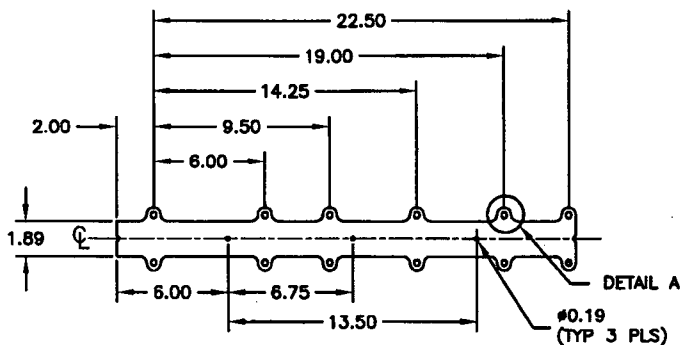
Measured by: PB	Audited by: S	Prototype Approval:	N/A
Date: 11-6-9	Date: 10/06/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	HA

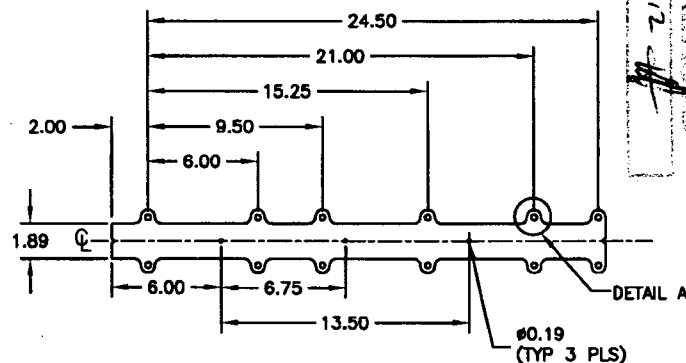
DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

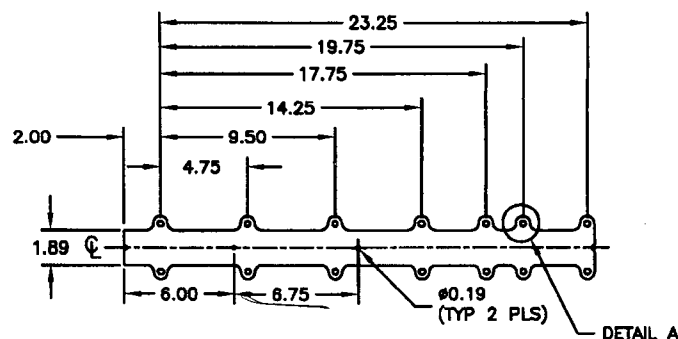
07.02.12
REL 06.07.10



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/6 74165